

Date: Tuesday, 08/04/2008 4:55:02 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 38466	
Estimate Number : 12300	
P.O. Number :	Part Number : D3488042
This Issue : 08/04/2008 S.O. No. :	Drawing Number : D3488 / DSK101
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B / D
Previous Run : 38100	Material :
Written By :	Due Date : 06/05/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JD 08-4-09</u>	
Comment : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 38101 x 2

36236 x 8

26 08/04/15

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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(P10) ->

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA627

2-Deburr

26 08/04/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

26 08/04/15

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

J.L 08/05/13

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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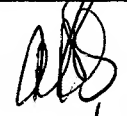

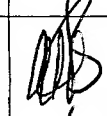


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3488-042 PAR #: N/A Fault Category: Prod/Machined Part NCR: (Yes) No DQA: D Date: 08/05/22
 QA: N/C Closed: D Date: 08/05/22

NCR: <u>38466</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/23	#2-D	0.297" hole was drilled to large by 0025" (0.321). RC hole wasn't drilled deep enough so when it was re-drilled it was too large. Also the plug was not installed during drilling.	 08/04/24	Scrap and Destroy no Replac. 08.04.23 QTY (+1)	SP 08/05/22 for Mathin Lactel	 08/05/22	 08/04/24	 08/04/23
								 08/04/23

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:55:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38466

Part Number: D3488042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

(10)

28 08/04/15

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. L. 08

(10X)

30 min

15/05/2008

S.244 11.05

#1 321

#2 338466

#3 D3488042

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M. L. 08/0

M107925

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 X10

10.0 ALS71032225 INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert M100489

X

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

sl

08-05-15

(V10)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/15 (44)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-22

sl

08-05-15

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:55:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38466

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

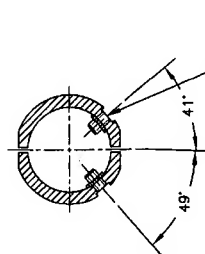
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

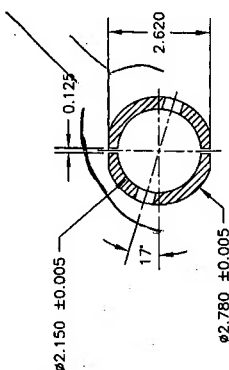
NOTE: Date & initial all entries

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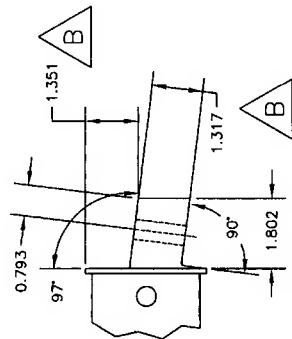
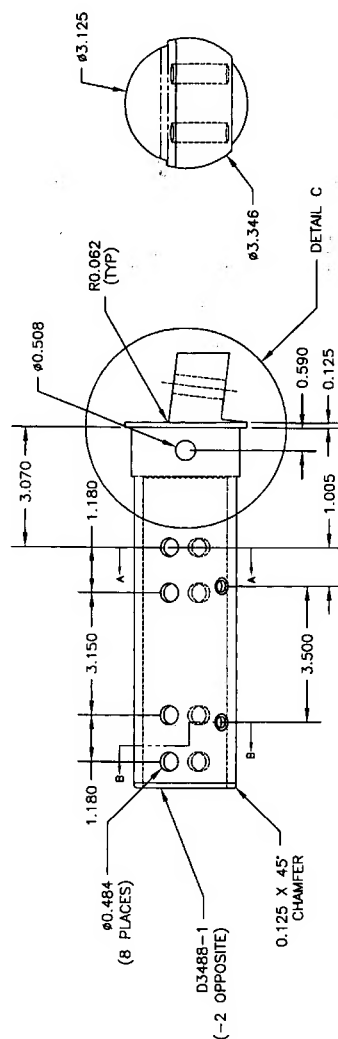
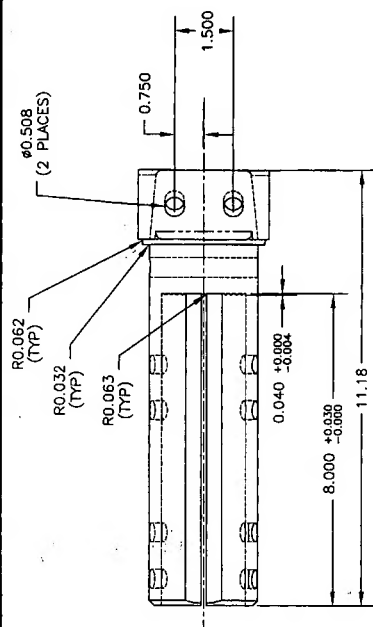


SECTION B-B

Ø0.297
C BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A



DETAIL C

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
4	D3488-041	BLADE FITTING ASSEMBLY (LH)
4	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	D3488-1	BLADE FITTING (LH)
1	D3488-2	BLADE FITTING (RH)
4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

- D3488-041/-042 BLADE FITTING
- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
 - FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
 - INSTALL INSERTS AFTER POWDER COAT
 - ALL DIMENSIONS ARE IN INCHES
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
R 06.03.15 PH
P212 DS
CIN #737

D3488-041 SHOWN (D3488-042 OPPOSITE)

DESIGN	DATE	BY	REVISION	CHANGE THICKNESS
A	06.03.15	PH	NEW ISSUE	
B	05.12.20	PH	APPROVED	
CHECKED	DATE	BY	APPROVED	
DRAWN BY	DATE	BY	APPROVED	

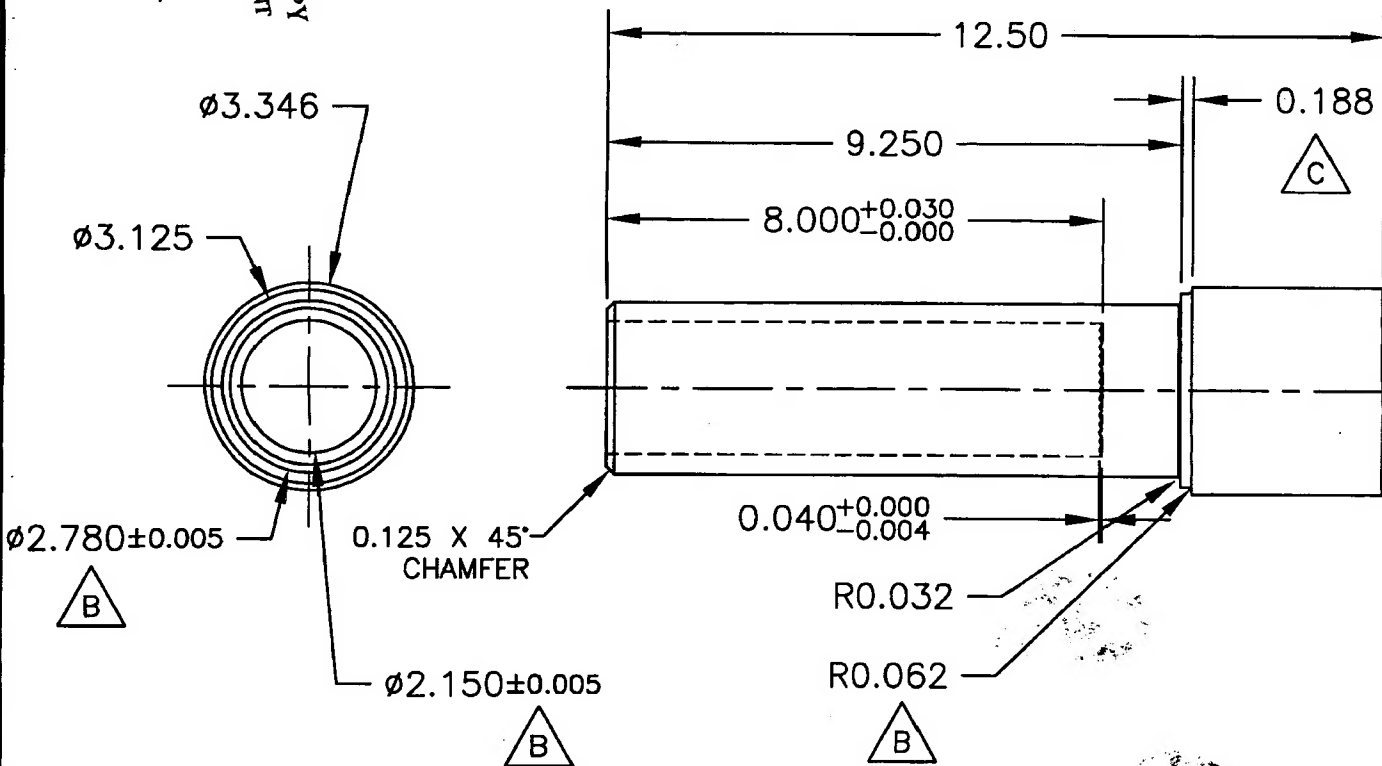
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DART AEROSPACE USA, INC.

DART AEROSPACE USA, INC.	REV. B
PORT HADCOCK, VA	SHEET 1 OF 1
DRAWING NO. D3488	SCALE
TITLE	BLADE FITTING
DATE	06.03.15
BY	PH
REVISION	NEW ISSUE
CHANGE THICKNESS	



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. 0
				DSK 101	SHEET 1 OF 1
DATE	06.05.09	TITLE	D3488-1/-2 TURNING DETAIL		
			SCALE	1:3	
A	05.12.21	NEW ISSUE			
B	06.03.02	ADD TOLERANCES AND RADIUS			
C	06.04.17	0.188 WAS 0.125			
D	06.05.09	REMOVE DIAMETER FOR CHAMFER			

26-05-09-14



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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